

4C

Dart Aerospace Ltd.

Date: Thursday, 3/23/2006 3:52:22 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> :	26370	<b>Part Number</b> :	D29382
<b>Estimate Number</b> :	10939	<b>Drawing Number</b> :	D2938 REV B
<b>P.O. Number</b> :	NIA	<b>Project Number</b> :	N/A
<b>This Issue</b> :	3/23/2006	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	NIA
<b>First Issue</b> :	3/23/2006	<b>Due Date</b> :	4/10/2006
<b>Previous Run</b> :	24960	<b>Qty:</b>	4 Um: Each
<b>Written By</b> :	SEE COMMENT BELOW		
<b>Checked &amp; Approved By</b> :	06-03-24 N		
<b>Comment</b> :	Est: B 0006.26 New DWG rev (mpp 2069) EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101003

7075-T7351 2X6.25X7.875



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B24891

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

JL 06/06/07

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JL 06/06/07

4.0

QC1

-INSPECT ALL DIM TO DIM SHEET



**Comment:** INSPECT ALL DIM TO DIM SHEET

JL 06/06/07

5.0

QC8

SECOND CHECK



**Comment:** SECOND CHECK

JL 06/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 06/06/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:52:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 26370

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/06/11

(4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06 06 13

(4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ref 6/14 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8476

Ref 6/14 (4)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Ref 06/06/15 (4)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26370
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

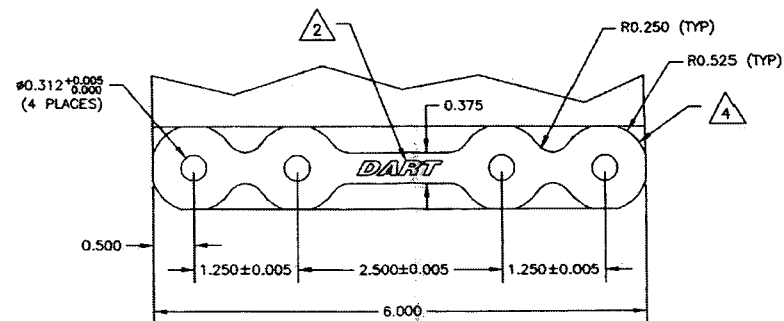
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.122	.122		
B	0.100	0.140		.120	.120	.121	.118		
C	0.100	0.140		.118	.115	.117	.121		
D	0.210	0.230		.221	.222	.223	.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.578		
J	2.495	2.505		2.499	2.501	2.500	2.500		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		.239	.240	.238	.239		
N	0.100	0.140		.123	.121	.122	.120		
O	0.540	0.560		.550	.551	.550	.550		
P	0.490	0.510		.500	.502	.503	.502		
Q	3.715	3.725		3.719	3.720	3.719	3.719		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.259	.259	.258	.258		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.366		
W	0.316	0.321	DT8690	✓	✓	✓	✓		
X	1.250	1.270		1.263	1.261	1.263	1.257		
Y	1.565	1.585		1.576	1.574	1.577	1.570		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject: 25

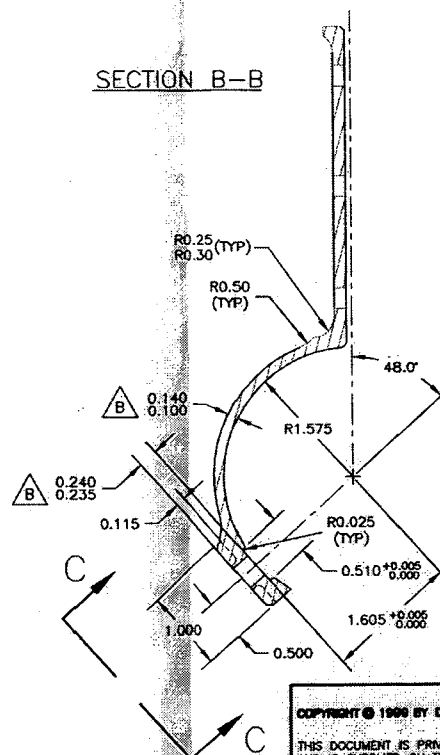
Measured by: J. S. J.
Date: 06/06/07

Audited by: E
Date: 06/06/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	



VIEW C-C



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005-4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005-4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASE  
00-05-31

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN #	DRAWN BY KF	<b>DART</b> DART AEROSPACE USA, INC. BELLVILLE, PA
CHECKED #	APPROVED #	DRAWING NO. D2938
DATE 00.05.29		TITLE SADDLE OUTSIDE
		REV. E SHEET 1 OF 2

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